

Work Order ID 51644

August 27, 2009 8:28:42 AM



Page 1

Item ID: D3641-4

Accept



Setup Start



Revision ID: B

Stop



Item Name: Cover

Start Date: 8/27/09 Start Qty: 10.00



Cust Item ID:

Required Date: 9/04/09 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan:

RP

Date: *09-8-27* Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

D3641	Rev B
-------	-------

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3641 ! Dwg Rev: B Prog Rev: B 2-
Deburr if necessary

JB 09/09/11

out of W37

HB 9-9-9



110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

HB 9-9-9

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

2> San/11



4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 51644

August 27, 2009 8:28:42 AM

Page 2

Item ID: D3641-4

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Required Date: 9/04/09

Req'd Qty: 10.00

Reference:

Accept

Setup Start

Stop

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Brake NC

Brake NC

NC BRAKE

Memo

Form as per Dwg D3641-1

→ PTO

0.00

0.00

8 09/09/04

8

8

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

27 09/09/04

28

1

150



HandFinish

Hand Finishing

Chemical Conversion Coat per QS1005 4.1

Memo

0.00

0.00

27 09/09/15

x f

6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
09.01.27	130	This Work order is for for a D3641-4. On page 2 of dws D3641, for <u>D3641-3</u> detail to construct D3641-4 = P DRAW NEEDS UPDATE UPDATED	AM	09.01.27	ALL	RA QSI 042 09.01.27	S 09/01/16

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 51644

August 27, 2009 8:28:42 AM



Page 3

Item ID: D3641-4

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Item Name: Cover

Start Date: 8/27/09

Start Qty: 10.00

Required Date: 9/04/09

Req'd Qty: 10.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Run Start



Stop



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160



QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

0.00

BR

09-09-15

8

170



Packaging

Packaging

Identify as per dwg & Stock Location:

240

Memo

0.00

0.00

7/9/16 82 SV

180



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

09/09/16 HJ

U 09-09-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

August 27, 2009 8:28:42 AM

Work Order ID: 51644

Parent Item: D3641-4RevB

Parent Item Name: Cover

Comments:

Start Date: 8/27/09

Required Date: 9/04/09

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6S.032		Purchased	No			100	sf	72.6500	8.2642			



6061-T6 Sheet 0.032"



B 9-9-9

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

72.65

110063

9.26

16954

8.99

18375

54.4

110063 X 8

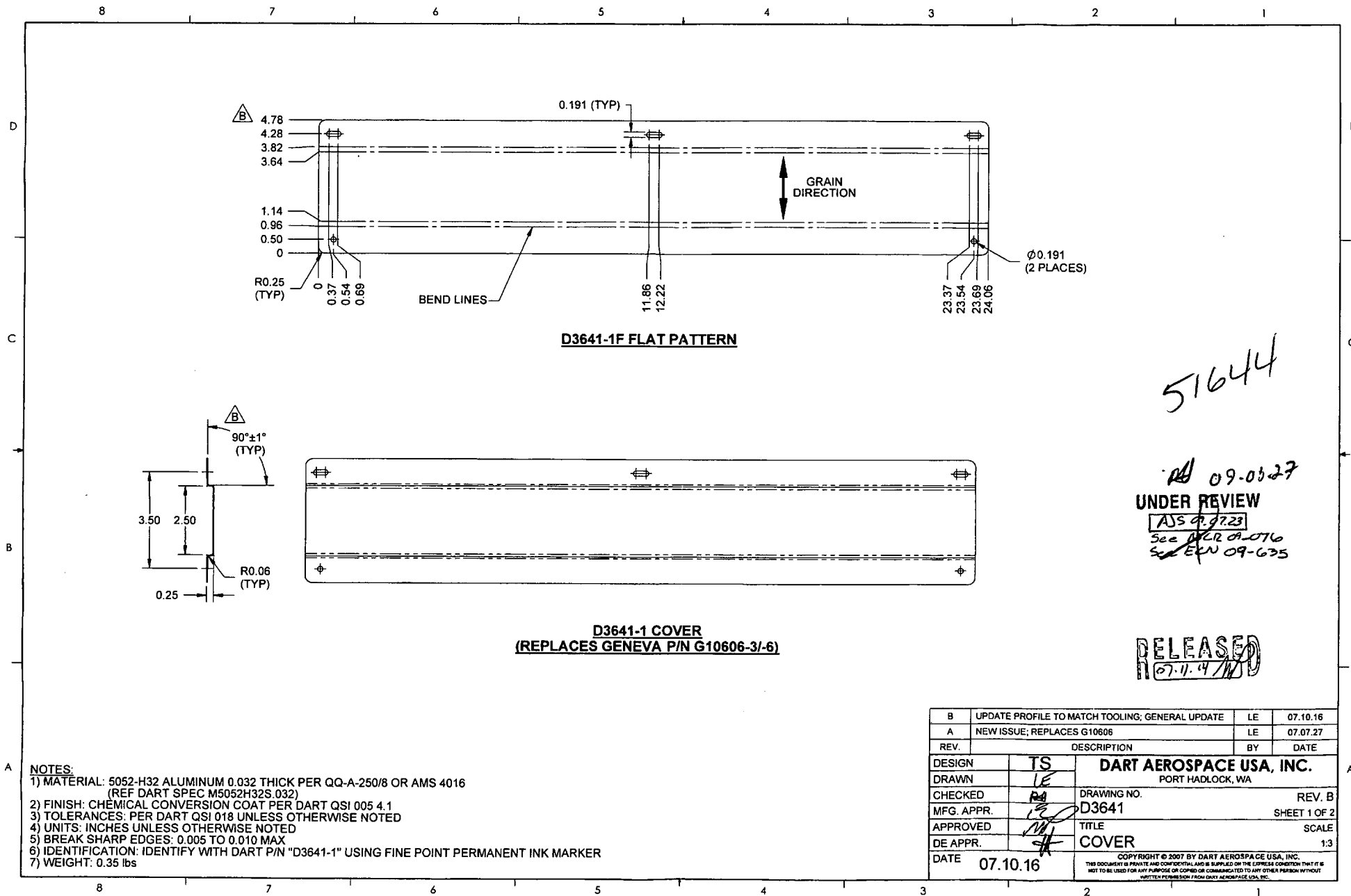
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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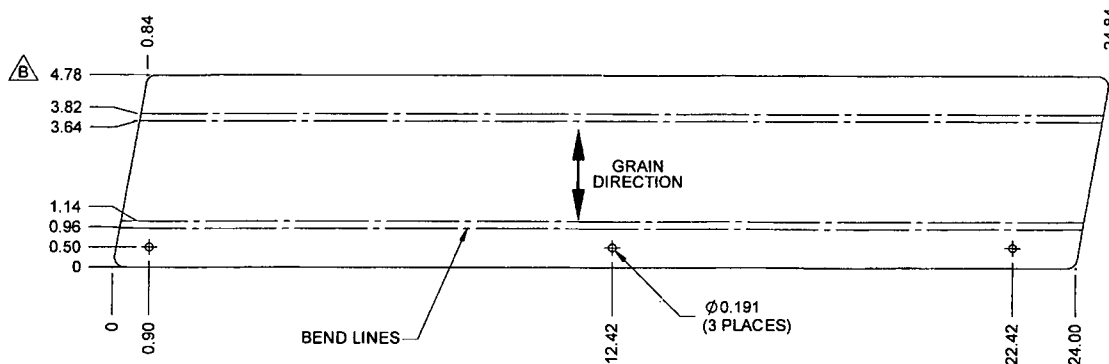
NOTE: Date & initial all entries



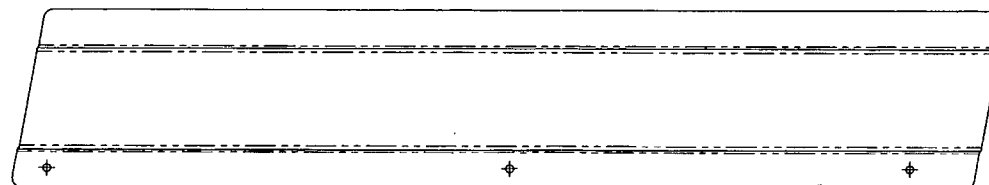
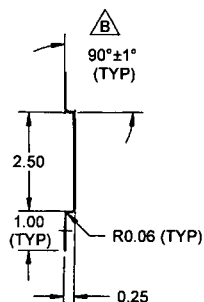
B	UPDATE PROFILE TO MATCH TOOLING; GENERAL UPDATE	LE	07.10.16
A	NEW ISSUE; REPLACES G10606	LE	07.07.27
REV.	DESCRIPTION	BY	DATE
DESIGN	TS		
DRAWN	LE		
CHECKED	RA		
MFG. APPR.	IS		
APPROVED	RA		
DE APPR.	RA		
DATE	07.10.16		

DART AEROSPACE USA, INC.		REV. B
PORT HADLOCK, WA		
DRAWING NO.	D3641	SHEET 1 OF 2
TITLE	COVER	SCALE
		1:3

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
D3641-3F FLAT PATTERN



D3641-3 COVER
(REPLACES GENEVA P/N G10606-5)
D3641-3 OPPOSITE
(REPLACES GENEVA P/N G10606-4)

NOTES:

- 1) MATERIAL: 5052-H32 ALUMINUM 0.032 THICK PER QQ-A-250/8 OR AMS 4016 (REF DART SPEC M5052H32S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3641-3/-4" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.36 lbs

DESIGN	TS	DART AEROSPACE USA, INC.	
DRAWN	LE	PORT HADLOCK, WA	
CHECKED	PH	DRAWING NO.	REV. B
MFG. APPR.	PH	D3641	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		COVER	1:3
DATE	07.10.16	COPYRIGHT © 2007 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

51644

PH 09.01.27

UNDER REVIEW

AS 09.07.23

See R 09-076

See R 09-635

RELEASED

6.11.14